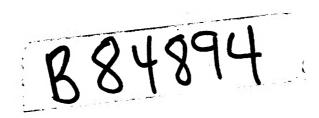
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84917

Page 1

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Revision ID:				14.5/(1	· / / /	, , ,,	•		1 🕠	') I
Item Name:	Skidtube RH							St	top *N	S2*
Start Date:	29/05/2012 Start Qty: 1.00	*1*		Cust Ite	m ID:					
Required Date:	16/07/2012 Req'd Qty: 1.00	*1*		Custome	er:					
Reference:										
Approvals:	Process Plan: MLブ	Date: 12/05/3	D Tooling:		Date:	-	F	Run St	art *N	R1*
	QC:	Date:		++++++++++++++++++++++++++++++++++++++				St	top	
	QC	_ Date:	_ SPC (Y/N):	`	Date:				*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool II	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D209-669-014	Rev B					÷				
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Work Orde <i>May-29-12 1:09</i>		917	atta t	*849	717*		3 35 8				T-15'	Page 2
Revision ID:	D209-669-0 Skidtube RH	—— (* * * * * * * * * * * * * * * * * *		Accept	*N900	040	100	*		Start Stop		S1*
	29/05/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:			·	осор	^N;	S2*
Approvals:		n:				ate:		j		Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC4- 100% Inspect kits Memo	s for completeness	0.00 (A)	5 11423		Couc					
*130		Packaging		0.00						2		,
Packaging Packaging		Memo Identify and Location:	d pack for shipping as per	0.00 PPPD209-669-014		•		(-/-	1/1	1/2 3	
140 *140* QC		QC21- Final Inspection	- Work Order Release	0.00			(りして	12	[07	23

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Work Order ID: 84917

84917

Parent Item: D209-669-014

Parent Item Name: Skidtube RH

D209-669-014

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

New IPP 08.02.13 new issue EC, verified by:DD IPP Rev:B 08-05-20 chg QTY of D2570 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D209-669-043		Manufactured	No		751255	110	Each	2.0000	1	1 .			
D209-669	9-043								**	848	F94	-2	//
7				Location	<u>1</u>	Loc	<u>Otv</u>	Loc Code			,		
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D2917-2		Manufactured	No		39206	110	ı Each	1 0000	_				\wedge
		Manufactured	140			110	Еасн	1.0000	· · · · · · · · · · · · · · · · · · ·	2	_)
D2917-2 Saddle RH	•								** B	18493	9	77	6
				Location	1	Loc (<u>Qty</u>	Loc Code					
				ST424			1						
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D2918-2		Manufactured	No			110	Each	1.0000	2	2		O	ת או
D2918-2 Saddle RH	444						1		** 7	18494	0	<u>ب</u>	6
				Location	!	Loc (Qty	Loc Code					
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Work Order ID: 84917		*Q	4917*		E - = 13			
Parent Item: D209-669-014 Parent Item Name: Skidtube RH			209-669-0	14*		Start Date Start Qty	:: 29/05/2012 :: 1.00	Required Date: 16/07/2012 Required Qty: 1.00
*AN4-51A *AN4-51A*	Purchased	No		110	Each	302.0000 8 **	8 5	
			Location 362	<u>Lo</u>	200 200 102 30 72	<u>Loc Code</u>	8	- - -
D2570 *D2570* Bushing	Manufactured	No		110	Each	711.0000 24	24	sP (
•			Location ST011 72960 78586 79493 81956 81957	<u>Lo</u>	711 41 9 12 24 400 225	<u>Loc Code</u>	24	
*MS21042L4 *MS21042I 4* Nut	Purchased	No		110	Each	4,095.000 2 ⁴	4 24	N 12/4/1
			Location ST300 119075 121011 121444 121652	<u>Lo</u>	4095 125 713 2957 300	Loc Code	24	- - -

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DATE	STEP	Description of NC			ction B	Verifi	cation	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		tion C	Chief Eng	QC inspector
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Work Order ID: 84917		*84	917*			4 - 4 - 4			18-18-19-1
Parent Item: D209-669-014 Parent Item Name: Skidtube RH			209-669-0	14*			Date: 29/05/2012	Required Dat Required Qt	
AN5-36A	Purchased	No		110	Each	184.0000 *:	4 4	le	
			Location 340 121181 121652 ST340 121708	Log	134 34 100 50 50	Loc Code	<i>¥</i>		
*AN960JD516 NAS11491 *AN960.ID516*	D0563J Purchased	No		110	Each	0.0000 ···	8 8 *	MI	195465
*MS21042L5 *MS21042L5 *Nut	Purchased	No		110	Each	1,447.000	4 4 *	le	
			Location 300 121652 ST300 108827 116105 116548 117611 119109 17651	Loc	500 500 947 8 5 43 18 865 8	<u>Loc Code</u>	<u> </u>		
/ AN4-7A ○ *AN4-7A* Bolt	Purchased	No		110	Each	124.0000	16 16 * M /	22/4/	12/7/13/
			Location ST356 117514 120770	Loc	124 24 100	Loc Code			K
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Work Order ID: 84917

Parent Item: Parent Item Name: Skidtube RH

D209-669-014

84917

Location

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53563

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ST021

ST351

D209-669-014

Start Date: 29/05/2012

Start Qty: 1.00

Required Date: 16/07/2012

Required Qty: 1.00

AN960JD416

NAS1149D0463J Purchased

No

110

Each

30.0000

Loc Code

32

32

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Manufactured No

119097

116289

20 110 Each

Loc Qty

30

10

86.0000

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Spacer

D2930

D2929

Spacer

∕D3405-041

Lug Assembly

Manufactured

Manufactured

No

110

86 Each

Loc Qty

86

Loc Qty

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102 102 110 6.0000 Each

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62227 2 77000 82031 82032

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May-29-12 1:09:15 PM									Page 5
Work Order ID: 84917 Parent Item: D209-669-014 Parent Item Name: Skidtube RH			4917* 209-669-0	14*			irt Date: 2	29/05/2012	Required Date: 16/07/2012 Required Qty: 1.00
AN4C47A	Purchased	No		110	Each	48.0000	4	4	Required Qty. 1.00
AN4C47A							**	M	12220481
			Location ST361 118451 119798 121009 121585	<u>Lo</u>	48 6 2 22 18	<u>Loc Code</u>			- - -
MS21043-4 *MS21043-4*	Purchased	No		110	Each	1,346.000	5 **	5	s D c
/			Location FG 104603 ST301 119546 121162	<u>Lo</u>	40 40 1306 147 659 500	<u>Loc Code</u>			- - - -
D3405-043 *D3405-043* Lug Assembly	Manufactured	No		110	Each	2.0000	** (-	1 84941	12/7/195
			<u>Location</u> ST478	Loc	2 Oty 2	Loc Code			l

82038

									
W/O:			WC	RK ORDER CHANG	ES				
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D3407-041 *D3407-041* Tow Ring	Manufactured	No		110	Each	27.0000	1 1	672	4
			<u>Location</u>	<u>L</u>	oc Qty	Loc Code			
			ST463		27				
			82067 82068 82108		6 19 2			 _	
D3456-1	Manufactured	No	02.00	110	Each	156.0000	1 1	\wedge	_
D3456-1						**	•	Je Je	
			Location	<u>L</u>	oc Qty	Loc Code			
			FG		7			_	
			25701		7				
			ST044		149			-	
/			80252 81876		l 10				
/			<u>81876</u> 83584		48 100			_	

D3417-5 *D3417-5* Washer

Manufactured

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 ST042
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

INSTRUCTIONS:

- 1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:
 - a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
 - b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
 - c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21913 MC

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REV.				DESCRIPTION	BY	DATE		
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DRAWN		Α	JS	HAWKESBURY, ONTAR	IO, CAN	ADA		
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MFG. AF	PR.	N/AD		DSI 9450		SHEET 1 OF 3		
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DATE	09.0	2.24		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR CORILD OF COMMUNICATION TO TO ANY OTHER HERSON WITHIN, WITH THE PROPERTY OF THE PROPERTY				

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5.0 PARTS LIST

x					-043	PART NUMBER	DESCRIPTION
^						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
	х					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
		x				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
			х			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
1	1			Х		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
		1	1		Х	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)
1		1 1		x x	1 X X	x x x 1 x x	X D209-669-013 X D209-669-014 X D209-669-041

IS:

		<u> </u>	1	I I		
50	4	4	1	1	D3405-041	LUG ASSEMBLY
51	8	8	4	4	AN4C47A	BOLT
52	16	16	8	8	D2570	BUSHING
53	8	8	4	4	MS21043-4	NUT
54			1	1	D3405-043	LUG ASSEMBLY
60	1	1	1	1	D3407-041	TOW RING ASSEMBLY
61	1	1	1	1	D3456-1	WASHER
62	1	1	1	1	MS21043-4	NUT
63	2	2	2	2	D3417-5	WASHER

WAS:

	1	1	Τ			
50	4	4	1	1	D2736-1	GHW LUG
51	8	8	4	4	AN4-46A	BOLT
52	16	16	8	8	D2570	BUSHING
53	8	8	4	4	MS21042L4	NUT (OR MS21042-4)
54			1	1	D2736-3	GHW LUG
60	1	1	1	1	D2968-041	TOW RING
61	1	1	1	1	AN970-4	WASHER
62	1	1	1	1	MS21042L4	NUT (OR MS21042-4)
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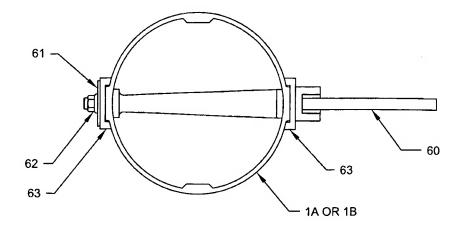
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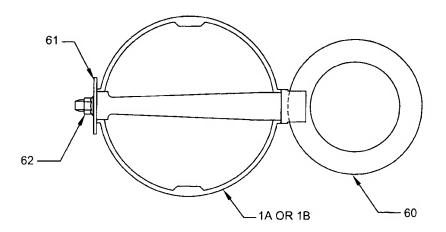
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NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

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